

Work Order ID 68580

Monday, April 18, 2011 9:28:18 AM



Page 1

Item ID: D4151-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 4/18/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: H

Date: 4-18-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut blank to 2.960" long

0.00

CR 4/10/27

8 0

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

1-MILL as per folio FA952 & dwg.

FOLIO REV: AA

DWG REV: 0

2-Deburr as required

0.00

29 11.5.3

8 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

RQ 11.8.3

8

✓

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

H.A 11/05/04

8

✓

Quality Control

140

Identify as per dwg & Stock Location: 134

0.00



Packaging

Memo

0.00

JB

11/05/04

Packaging

Dart Aerospace Ltd

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/10 JH

MF
11-05-05

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Picklist Print

Monday, April 18, 2011 9:28:25 AM

Page 1

Work Order ID: 68580

Parent Item: D4151-7

Parent Item Name: Fwd Eyebolt Receiver (Upper)


Start Date: 4/18/2011

Required Date: 4/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP
Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	10.6000	0.26	2.189474			
													

303 BAR 2" X 1.750"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	10.6	
<i>7</i> 115047	10.6	

2.190 *cm 4/16/27*

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DART AEROSPACE LTD		Work Order: 68380
Description: Fwd Eyebolt Receiver (Upper)		Part Number: D4151-7
Inspection Dwg: D4151	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.253			20.02	
1.250	+/-0.010	1.248				
0.09 x 45°	+/-0.030 x 0.5°	.095 x 45°				
1.00	+/-0.030	1.001				
R0.13	+/-0.030	R.13				
Ø0.191	+0.005/-0.001	—				
R0.19	+/-0.030	R.19				
0.96	+/-0.030	.963				
0.09 x 45°	+/-0.030 x 0.5°	.095 x 45°				
0.350	+/-0.010	.352				
Ø0.257	+0.006/-0.001	.257				
1.110	+/-0.010	1.113				
1.000	+/-0.010, .002	1.000				
2.76	+/-0.030	—				
0.225	+/-0.010	.225				
0.800	+0.000/-0.010	.798				
1.80	+/-0.030	—				
0.88	+/-0.030	.900				
0.09 x 45°	+/-0.030 x 0.5°	.095 x 45°				
Ø0.734	+0.010/-0.000	.738				
2.84	+/-0.030	2.837				
1.88	+/-0.030	1.875				

Measured by: RQ 11.5.3
Date:

Audited by: B.A
Date: 11/05/04

Preliminary Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.08.25	Tolerance revised for dimension 0.800	KJ	

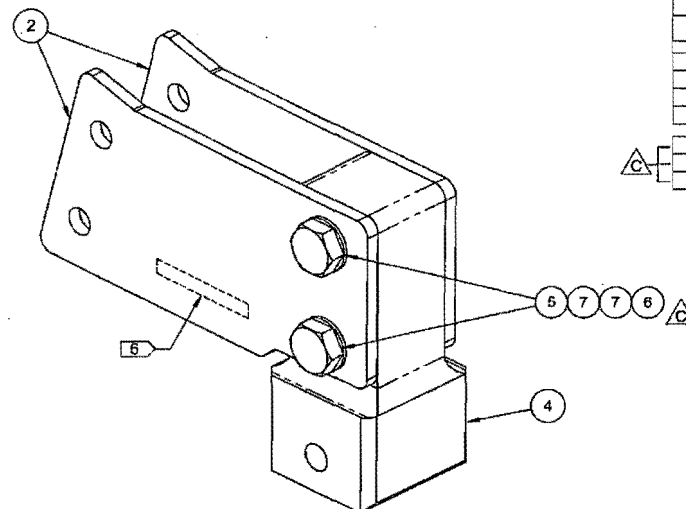
Dart Aerospace Ltd

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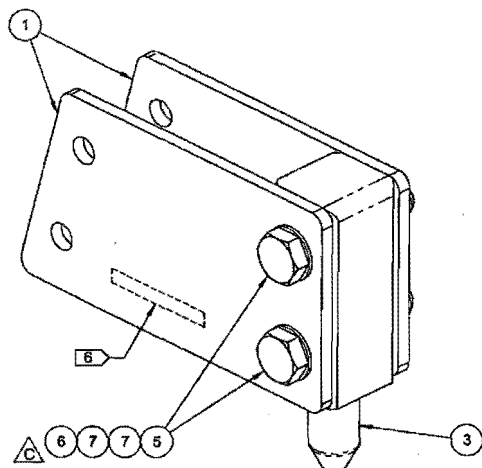
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D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68580

PH-04-10

RELEASED
2011-01-28
MR

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5SD. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2) REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.08.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>		
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3

TITLE **BASKET FWD HARDPOINT** SCALE NTS

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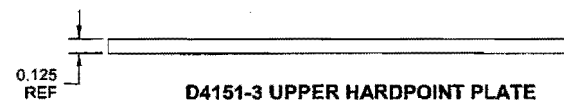
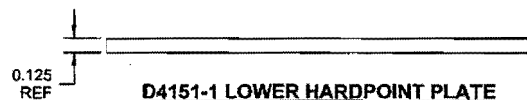
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
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APPROVED			SCALE	
DE APPR.			NTSS	
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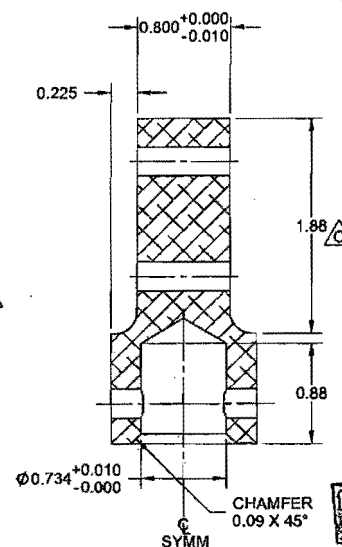
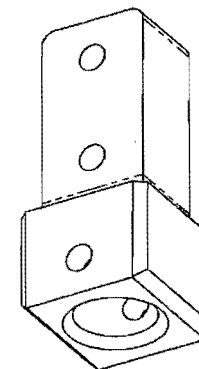
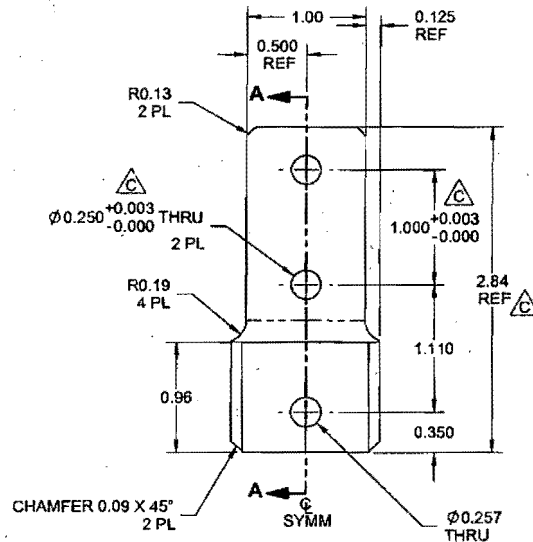
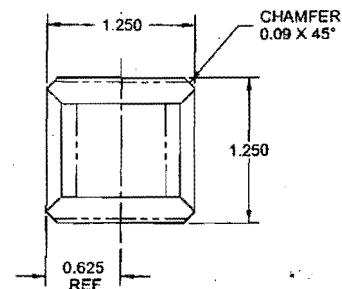
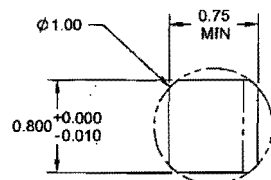
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D4151-7 FWD EYEBOLT RECEIVER (UPPER)

SECTION A-A

1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN	15	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D4151 TITLE BASKET FWD HARDPOINT COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPERTY OF DART AEROSPACE LTD. NO PART OF THIS DOCUMENTATION IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	REV. C
DRAWN	JS		SHEET 3 OF 3
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MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
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